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D3535-13
Job Sheet 191086



Part No: D3535-13

Job Qty: 8 pcs

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3535 REV.C IPP Rev:A New Issue 07-02-15 JLM IPP Rev:B As per Rev B 07-08-31 JLM Verified
By:EC IPP REV:C 18.11.09 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		4/12/19	0.00	0.76	Waterjet - Flow		2019/04/29
120	QC 8	6 pcs		4/12/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
130	Small Fab - Brake NC - B4B	6 pcs		4/12/19	1.67	0.17	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
140	QC 5	6 pcs		4/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		

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					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
150	Powdercoat - 3 Grey Sand - B4B	6 pcs	4/12/19	0.00 0.10	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	6 pcs	4/12/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
170	Packaging 3-1 - Stock - B4B	6 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

DAS
APR 29 2019 40
9-89

BK 19-4-30

150 Powdercoat - 3 Grey Sand - B4B

6 pcs

4/12/19

0.00 0.10

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

160 QC 3

6 pcs

4/12/19

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 26

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 6

QC 3 - 68

QC 3 - 9

DAS
APR 30 2019 40
9-89

170 Packaging 3-1 - Stock - B4B

6 pcs

4/12/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	APR 30 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
180 QC 21 - SA	6	4/12/19	0.00 0.00	QC 21 - SA - 21	DAG
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	5-89

Part Op 100 - 1-Cut as per Dwg D3535 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg) 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13

140 - QC5- Inspect part completeness to step on W/O)

150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: _____

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	5.1600 sf (.86 ea)	100-Waterjet - Flow - 1	5175151

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	5	59	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	1.885inches $\pm$ 0.010	1.895 1.875		
2	Wearshoe	2.000inches $\pm$ 0.010	2.010 1.990		
3	Wearshoe	5.650inches $\pm$ 0.010	5.660 5.640		
4	Wearshoe	9.150inches $\pm$ 0.010	9.160 9.140		
5	Wearshoe	14.066inches $\pm$ 0.010	14.076 14.056		
6	Wearshoe	18.983inches $\pm$ 0.010	18.993 18.973		
7	Wearshoe	23.900inches $\pm$ 0.010	23.910 23.890		
8	Wearshoe	27.400inches $\pm$ 0.010	27.410 27.390		
9	Wearshoe	29.400inches $\pm$ 0.010	29.410 29.390		
10	Wearshoe	32.900inches $\pm$ 0.010	32.910 32.890		
11	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187		
12	Wearshoe	20.000inches $\pm$ 0.030	20.030 19.970		
13	Wearshoe	14.000inches $\pm$ 0.030	14.030 13.970		
14	Wearshoe	8.000inches $\pm$ 0.030	8.030 7.970		
15	Wearshoe	5.000inches $\pm$ 0.030	5.030 4.970		
16	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
17	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
18	Wearshoe	0.038inches $\pm$ 0.010	0.048 0.028		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

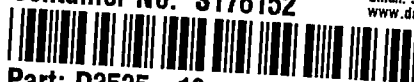
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S176152



Part: D3535-13

Job No: 191086

Serial No/Batch: S176152

Revision: C

Inspector:

Exp Date:

Instructions: URF16-638

Date: 04/29/19